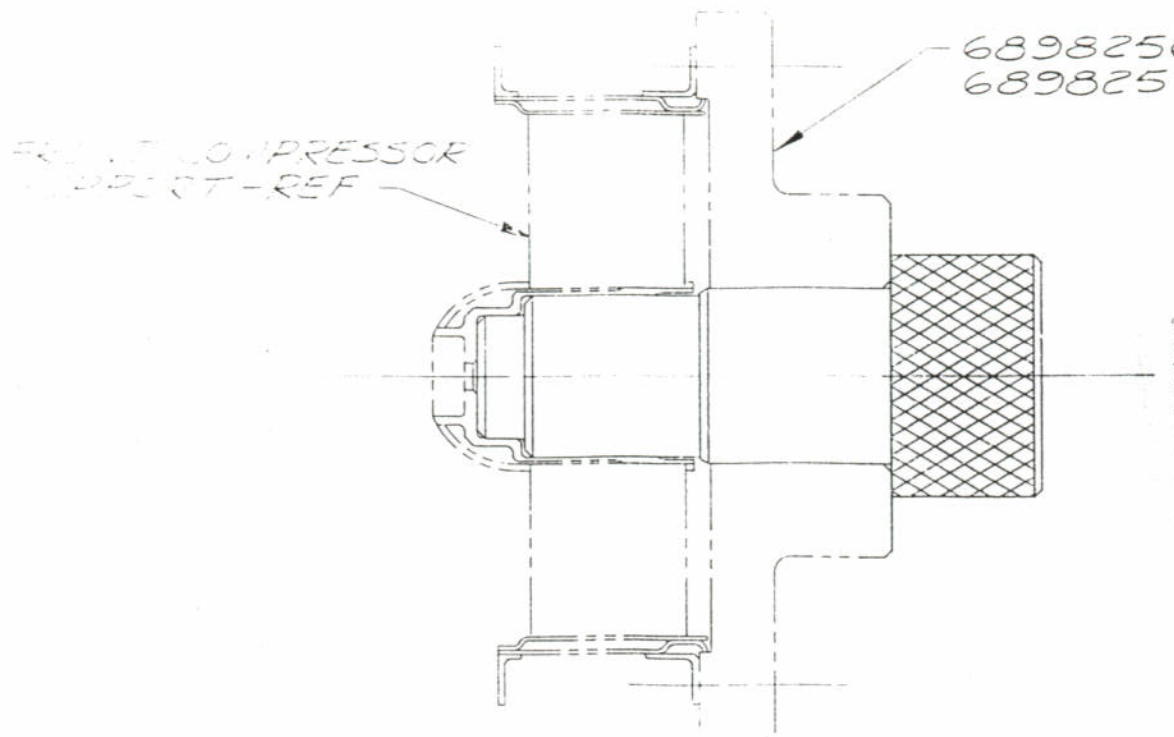
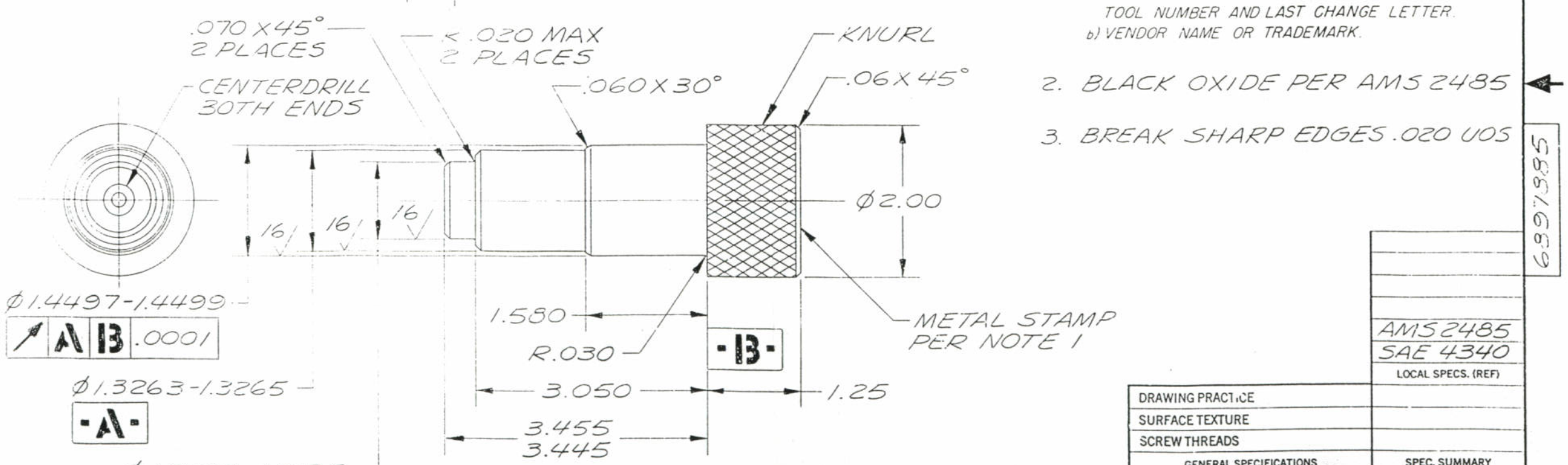
REVISIONS				
MICRO-FILMED	LTR	DESCRIPTION	DATE	APPROVED



These tool drawings are furnished in accord with the terms of the DDA Tools Release Agreement. The aperture cards or drawings are to be maintained in the custody of the recipient and shall not be disclosed to any third party without specific written consent of Detroit Diesel Allison Division of GMC.

REDUCED PRINT



NOTES:

1. MARK AS SPECIFIED IN LOCATION SHOWN WITH 1/8-3/16 HIGH FIGURES THE FOLLOWING:
   a) THE NAME "ALLISON" FOLLOWED BY THE TOOL NUMBER AND LAST CHANGE LETTER.
   b) VENDOR NAME OR TRADEMARK.
2. BLACK OXIDE PER AMS 2485
3. BREAK SHARP EDGES .020 UOS

6897885

AMS 2485
SAE 4340
LOCAL SPECS. (REF)

DRAWING PRACTICE	
SURFACE TEXTURE	
SCREW THREADS	
GENERAL SPECIFICATIONS	SPEC. SUMMARY

REF—

EACH ITEM PURCHASED SEPARATELY MUST BE STAMPED OR ETCHED WITH TOOL NUMBER AND DETAIL NUMBER. IF SUITABLE OR SUFFICIENT AREA NOT AVAILABLE, ATTACH TAG.

GEOMETRIC CHARACTERISTIC SYMBOLS

FLATNESS	PERPENDICULARITY	(M) OR MMC (MAX MATL CONDITION)
STRAIGHTNESS	PARALLELISM	(S) OR RFS (REGARDLESS OF FEATURE SIZE)
ROUNDNESS	ANGULARITY	X.XXXX BASIC DIM
CYLINDRICITY	RUNOUT	Ø DIAMETER
PROFILE OF A LINE	TRUE POSITION	-A- DATUM IDENT
PROFILE OF A SURFACE	CONCENTRICITY	
	SYMMETRY	

UNLESS OTHERWISE SPECIFIED:
ALL TRUE POSITION TOLERANCES AND RELATED DATUMS MMC.
ALL OTHER FORM AND POSITIONAL TOLERANCES AND RELATED DATUMS RFS.
SEPARATE TRUE POSITION CALLOUTS MAY BE GAGED SEPARATELY REGARDLESS OF DATUM REFERENCE.
RUNOUTS ARE CIRCULAR.

UNLESS OTHERWISE SPECIFIED	
TOL. ON ANGLES ±	1°
TOL. ON 3 PLACE DECIMALS ±	.010
TOL. ON 2 PLACE DECIMALS ±	.02
MATL.	STEEL SAE4340
HEAT TREAT AND HARDNESS	Rc 32-36
SURFACE TREAT.	SEE NOTE
INSPECTION	

APPROVALS		DATE
DRAWN	ROSS/SUR	78-4-21
CHECKED	GOSSETT/RM	78-6-13
CHF. DR.		78-6-13
MET.		
ENGR. 1	R.GRISWOLD	78-5-9
ENGR. 2		
ENGR. 3		
FINAL	E.REAGAN	78-6-6
REVIEW APPROVAL		

Detroit Diesel Allison
Division of General Motors Corporation
Indianapolis Operations

TITLE
PLUG-ALIGNMENT CHECK, FRT SUPPORT BEARING HSG BORE

MODEL (FIRST USAGE) 250 SERIES | APPLICATION: SEE SEPARATE PARTS LIST

SIZE	CODE IDENT.	DWG. No.
C	73342	6897885

SCALE 1/1 | SHEET

FILE COPY

FORM 852C (REV. 6-75)